

Work Order ID 143589

March 16, 2016 1:52:10 PM

143589

Page 1

Item ID: D412-761-049

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Armrest

Stop ***NS2***

Start Date: 4/15/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/26/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SLT Date: 120160316

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-761	E
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100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-761-049 CHG004

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
3
9-89

MLJ 1604-20

2X

DAS
28
9-89

APR 27 2016

2X MLJ

DAS
27
9-89

16-04-20

2X

DAS
28
9-89

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER : _____									

Work Order ID 143589

143589

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Item ID: D412-761-049 Accept ***N1900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest
 Start Date: 4/15/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/26/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				2x DAS 28 9-89		APR 27 2016	
Packaging	Identify and pack for shipping as per PPP D412-761-049								
	Location: _____								
	PPP Rev: _____								
		PPP143586							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS MAY 02 2016

MF
16-4-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 143589

143589

Parent Item: D412-761-049

D412-761-049

Parent Item Name: Armrest

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 08-09-10 new issue DD verified by:JLM

IPP Rev:B 09-01-13 rev.C as per dwg DD verified by:EC

IPP REV:C

12.03.06 AS PER ECN12-535 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3694-041 *D3694-041* Mounting Plate		Manufactured	No			110	Each	2.0000	1	(2)			
									**			MLJ 16-04-20	DAS 27 9-89
	DAS 28 9-89												
					Location			Loc Qty		Loc Code			
					ST505			2					
					134419			2					
D3695-041 *D3695-041* Slider Assembly		Manufactured	No			110	Each	2.0000	1	2			
									**			MLJ 16-04-20	DAS 27 9-89
	DAS 28 9-89												
					Location			Loc Qty		Loc Code			
					ST506			2					
					111437			1					
					116389			1					
D3780-041 *D3780-041* Armrest Assembly		Manufactured	No			110	Each	0.0000	1	2			
									**			139237	DAS 27 9-89
	DAS 28 9-89												
AN3-6A *AN3-6A* Bolt		Purchased	No			110	Each	273.0000	11	(22)			
									**			MLJ 16-04-20	DAS 27 9-89
	DAS 28 9-89												
					Location			Loc Qty		Loc Code			
					over003			175					
					M134055			175					
					ST349			98					
					M133932			98					

Picklist Print

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Work Order ID: 143589

143589

Parent Item: D412-761-049

D412-761-049

Parent Item Name: Armrest

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

AN6-26

Purchased

No

110

Each

18.0000

1

AN6-26

Bolt

DAS
28
9-89

**

MLS 16-04-20

LocationLoc QtyLoc Code

ST334

18

m127124

18

DAS
27
9-89

AN320-6

Purchased

No

110

Each

29.0000

1

AN320-6

Nut

DAS
28
9-89

**

MLS 16-04-20

LocationLoc QtyLoc Code

ST330

29

113288

28

116392

1

DAS
27
9-89

NAS1149D0363J

Purchased

No

110

Each

1,852.000

11

NAS1149D0363.J

Washer

DAS
28
9-89

**

MLS 16-04-20

LocationLoc QtyLoc Code

GA

40

m130799

40

ST263

1812

m134055

812

m134370

1000

DAS
27
9-89

NAS1149D0616J

Purchased

No

110

Each

184.0000

1

NAS1149D0616.J

WASHER

DAS
28
9-89

**

MLS 16-04-20

LocationLoc QtyLoc Code

ST269

184

122815

184

DAS
27
9-89

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Page 2

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Work Order ID: 143589

143589

Parent Item: D412-761-049

D412-761-049

Parent Item Name: Armrest

Start Date: 4/15/2016

Required Date: 4/26/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1515H6L

Purchased

No

110

Each

96.0000

2

(4)

***NAS1515H6L ***

Washer

**

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST265

96

18918

1

m128612

6

m128637

89

4

MS24665-302

Purchased

No

110

Each

44.0000

1

(2)

MS24665-302

Cotter Pin

**

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

17

120521

17

ST288

27

m127305

27

2
6

MS21071L3

Purchased

No

110

Each

208.0000

3

MS21071L3

ANCHOR NUT

**

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST299

108

124291

4

m129702

104

ST301

100

125654

100

6

MS21075L3

MS21075L3N

Purchased

No

110

Each

228.0000

8

16

MS21075L3

Nut Plate

**

MLJ 16-04-20

BAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

228

m134257

228

16

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(CONTINUED FROM PAGE 11)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
					1			D3780-041	ARMREST ASSEMBLY
					1			D3696-041	* ARM ASSEMBLY
					1			D3696-1	** ARM
					1			D3801-3	** HAND RETRACTABLE SPRING PLUNGER
					1			D3781-041	* LATERAL CUSHION ASSEMBLY
					1			D3781-043	* ARMREST CUSHION ASSEMBLY
					1			D3785-3	* BRACKET
					1			D3977-1	* BOLT
					1			D3978-1	* NUT (CASTELLATED)
					1			D3979-1	* WASHER (SQUARE HOLE)
					2			AN970-6	* WASHER
					1			MS24665-302	* COTTER PIN
					2			MS21042L3	* NUT
					2			MS24693-C272	* SCREW
					2			MS24693-C277	* SCREW
					1			NAS1149D0663J	* WASHER (OR AN960JD616)
					11			AN3-6A	BOLT
					1			AN6-26	BOLT
					1			AN320-6	CASTELLATED NUT
					11			NAS1149D0363J	WASHER (OR AN960JD10)
					1			NAS1149D0616J	WASHER (OR AN960JD616L)
					2			NAS1515H6L	WASHER
					1			MS24665-302	COTTER PIN
					3			MS21071L3	ANCHORNUT
					8			MS21075L3	NUTPLATE
						1		D4097-041	ARMREST ASSEMBLY
						1		D3696-041	* ARM ASSEMBLY
						1		D3696-1	** ARM
						1		D3801-3	** HAND RETRACTABLE SPRING PLUNGER
					1			D4098-041	* CUSHION ASSEMBLY
					1			D4099-1	* BRACKET
					3			MS21042L3	* NUT
					5			MS24693-C273	* SCREW
					3			MS24693-C277	* SCREW
					1			NAS1149D0332J	* WASHER
					11			AN3-6A	BOLT
					1			AN6-26	BOLT
					1			AN320-6	CASTELLATED NUT
					11			NAS1149D0363J	WASHER (OR AN960JD10)
					1			NAS1149D0616J	WASHER (OR AN960JD616L)
					2			NAS1515H6L	WASHER
					1			MS24665-302	COTTER PIN
					3			MS21071L3	ANCHORNUT
					8			MS21075L3	NUTPLATE
							4	D3932-1	SNAP VENT

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE
 ** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED FROM PAGE 10)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
				1				D3705-041	INSTRUMENT PANEL ASSEMBLY
				1				D3705-043	* INSTRUMENT PANEL WELDMENT
				1				D3335-1	* SPRING
				1				D3705-5	* ACCESS PANEL
				1				D3706-041	* LOCK BRACKET ASSEMBLY
				1				D3706-5	* PIN
				2				D3707-3	* MOUNTING LUG
				2				AN3-3A	* BOLT
				4				AN526C1032R6	* SCREW
				1				MS171498	* SPRING SLOTTED PIN
				4				MS24693-C272	* SCREW (OR MS24693-S272)
				2				NAS1149D0332J	* WASHER (OR AN960JD10L)
				1				NAS1149D0563J	* WASHER (OR AN960JD516)
				1				D3705-7	FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-9	FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1				D3705-11	FACE PLATE (FOR 212, 214, 412, MODELS)
				2				D3707-1	MOUNTING LUG
				1				D3790-1	INDEXING BLOCK
				1				D3867-1	CONNECTOR PLATE
				2				D4758-1	BLANKING PLATE
				3				D4758-3	BLANKING PLATE
				4				AN3-4A	BOLT
				6				AN526C1032R6	SCREW
				2				AN743-12	BRACKET
				6				AN960JD10L	WASHER
				6				MS21075L3	NUTPLATE (OR MS21073-3)
				4				MS24693-C272	SCREW (OR MS24693-S272)
				1				MS27039-1-17	SCREW
				1				MS27039-1-27	SCREW
				4				MS21042L3	NUT
				2				MS21919WDG8	CLAMP
				4				NAS1149D0332J	WASHER (OR AN960JD10L)
					1	1		D3694-041	MOUNTING PLATE ASSEMBLY
					1	1		D3694-1	* KEYWAY
					1	1		D3694-3	* PROTECTIVE PLATE
					1	1		D3694-5	* MOUNTING PLATE
					1	1		AN526C1032R8	* SCREW
					4	4		MS21042L3	* NUT
					2	2		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					1	1		MS24693-C271	* SCREW (OR MS24693-S271)
					4	4		MS24693-C273	* SCREW (OR MS24693-S273)
					5	5		NAS1149D0363J	* WASHER (OR AN960JD10)
					1	1		D3695-041	SLIDER ASSEMBLY
					1	1		D3695-1	* SLIDER
					1	1		D3695-3	* STOPPER
					1	1		MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					4	4		MS24693-C276	* SCREW (OR MS24693-S276)
					1	1		D3801-1	* HAND RETRACTABLE SPRING PLUNGER

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 12)

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Revision: E
Date: 12.12.07